

Work Order ID 158205

Wednesday, March 15, 2017 12:35:59 PM

158205

Page 1

Item ID: D4366-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Fwd
Start Date: 3/16/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED
Approvals: Process Plan:  Date: MAR 15 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4366	C								

110

0.00

110

Large Fab

1.25

Large Fab

Memo

FRONT BENT (1.37) COULD BE OVER BENT HIGHER BY 0.25"-0.50"

1- Weld D4367-041 to wearplate by positioning holes together as per dwg D4366
304 S.S. Welding Rod
BATCH #: M134442

2- Transfer drill holes in bar and cut extra material on bar if necessary

1 Q 17-3-17

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

① 17.03.17 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

158205

Wednesday, March 15, 2017 12:35:59 PM

N900040100

Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

*** 1 ***

Customer:

Required Date: 3/22/2017 **Req'd Qty:** 1.00

Reference: SCHEDULED

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

130

0.02

QC

Quality Control

Memo

***FRONT BENT (1.37) COULD BE OVER BENT HIGHER BY 0.25"-0.50". ***

① 17.03.17 PD

0.00

140

0.04

Small Fab

Small Fab

Memo

1- After finish, coat entire top (concave) surface as per note 9 dwg D4366.
TEXTURED COATING B#: 136470

1 9-89

MAR 17 2017

0.00

150

0.02

QC

Quality Control

Memo

38

MAR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 16.6%;">Skid-tube ☐</td> <td style="width: 16.6%;">Cross tube ☐</td> <td style="width: 16.6%;">Water Jet ☐</td> <td style="width: 16.6%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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EAG FB 4-8								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
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OTHER : _____																																																															

Work Order ID 158205

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Page 3

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Revision ID: Stop ***NS2***
Item Name: Run-on Landing Wearplate Fwd
Start Date: 3/16/2017 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>F2-002</u>	0.00							
160									
Packaging	Memo	0.01				x1	1	17/03/20	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							17/3/21
Quality Control									

MAR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, March 15, 2017 12:36:03 PM

Page 1

Work Order ID: 158205

158205

Parent Item: D4366-041

D4366-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 3/16/2017

Required Date: 3/22/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC IPP REV:B
14.02.06 DWG PB1 DD VERF:JLM IPP REV:C 14.04.22
DWG B DD VERF:JLM IPP REV:D 14.05.28 DWG PC1
DD VERF:JLM IPP REV:E 16.06.17 DWG.C DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4366-1		Manufactured	No			110	Each	7.0000	1	1			

D4366-1

Plate

AL 17-3-15

Location

Loc Qty

Loc Code

WA001

7

128063

3

151530

4

D4367-041

Manufactured No

110

Each

4.0000

1

1

D4367-041

Bar Weldment

AL 17-3-15

Location

Loc Qty

Loc Code

WA001

4

150492

2

151559

2

DQA: _____ Date: _____



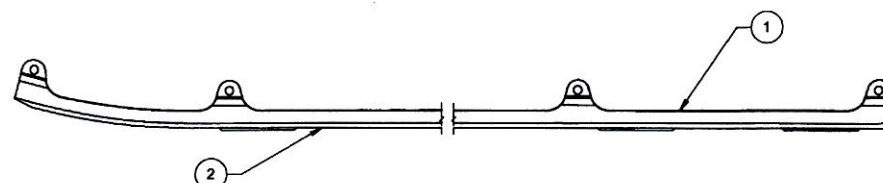
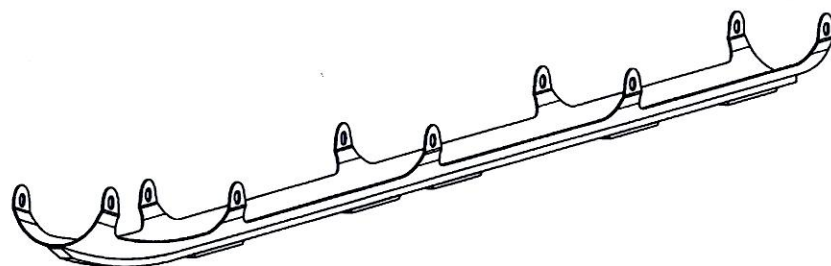
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4366-041	WEARPLATE ASSY
1	1	D4366-1	PLATE
2	1	D4367-041	BAR



D4366-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-041" PER QSI 044 6.1
- 7) WEIGHT: D4366-041 = 5.30 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES THRU D4367-041 BAR WELDMENT FROM D4366-1 WEARPLATE AFTER WELDING

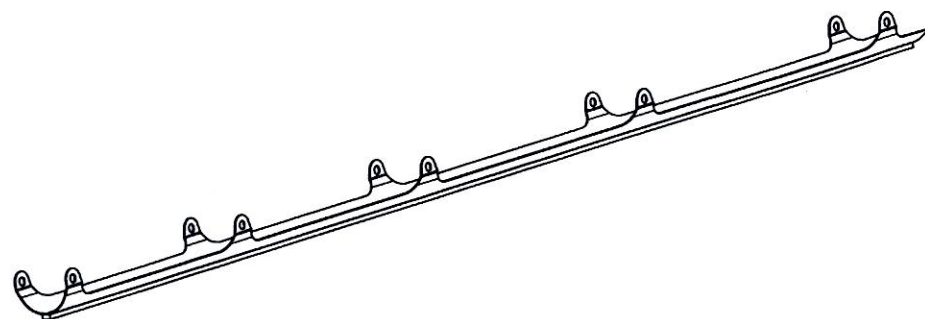
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158205
MAR 15 2017

RELEASED
2016-06-16
EN14-594

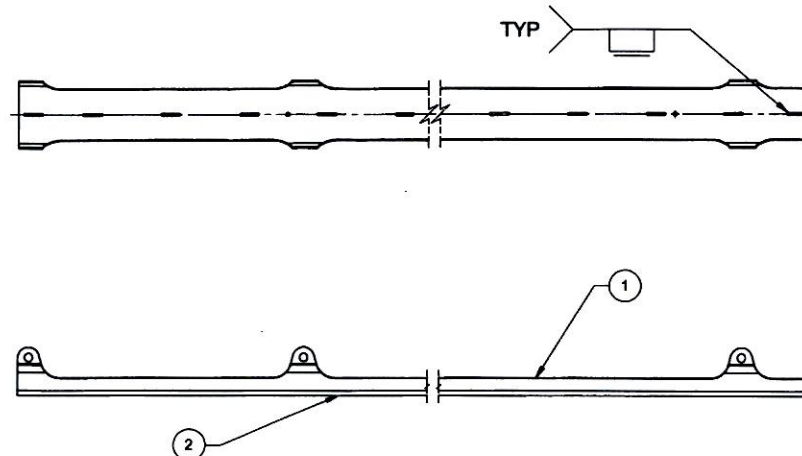
C	D4367-041 WAS D4367-1, D4367-043 WAS D4367-3, REMOVE HARDCOAT WELD (MOVED TO D4367), UPDATE TOLERANCES, PART WEIGHTS (SH 384), RELABELED VIEWS, UPDATE NOTES	DB	16.04.11
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), REVISE NOTE 10 (SH 2),	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4366-043	WEARPLATE ASSY
1	1	D4366-3	PLATE
2	1	D4367-043	BAR WELDMENT



D4366-043 AFT WEARPLATE ASSY



NOTES:

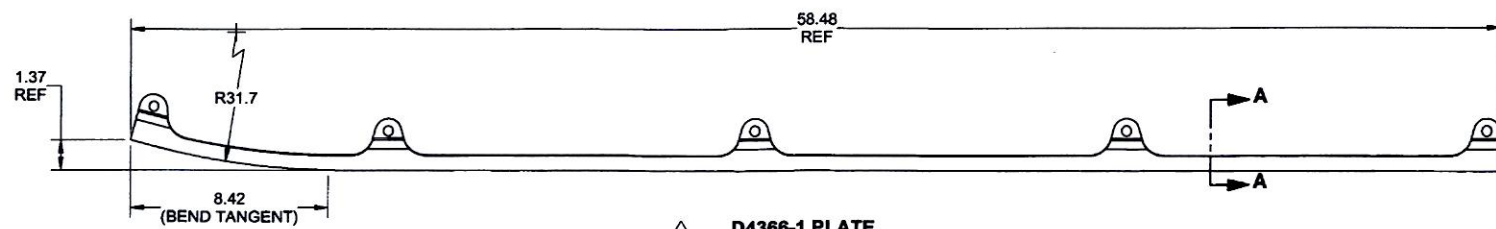
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-043" PER QSI 044 6.1
- 7) WEIGHT: D4366-043 = 6.56 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL Ø0.188 HOLES THRU D4367-043 BAR WELDMENT FROM D4366-3 WEARPLATE AFTER WELDING



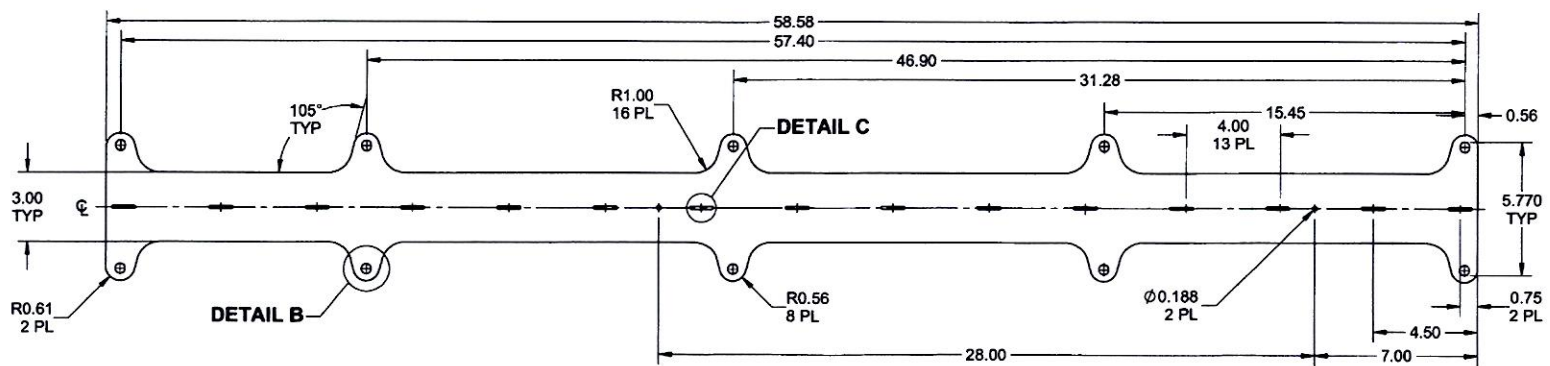
RELEASED
2016-06-16

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO. D4366	REV. C
MFG. APPR.	DD		SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4366-1 PLATE
(MAKE FROM D4366-1F)



D4366-1F PLATE
(FLAT PATTERN)

NOTES:

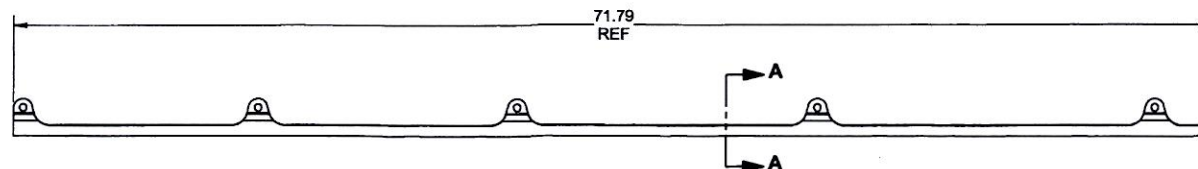
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.79 lbs

RELEASED
2016-06-16

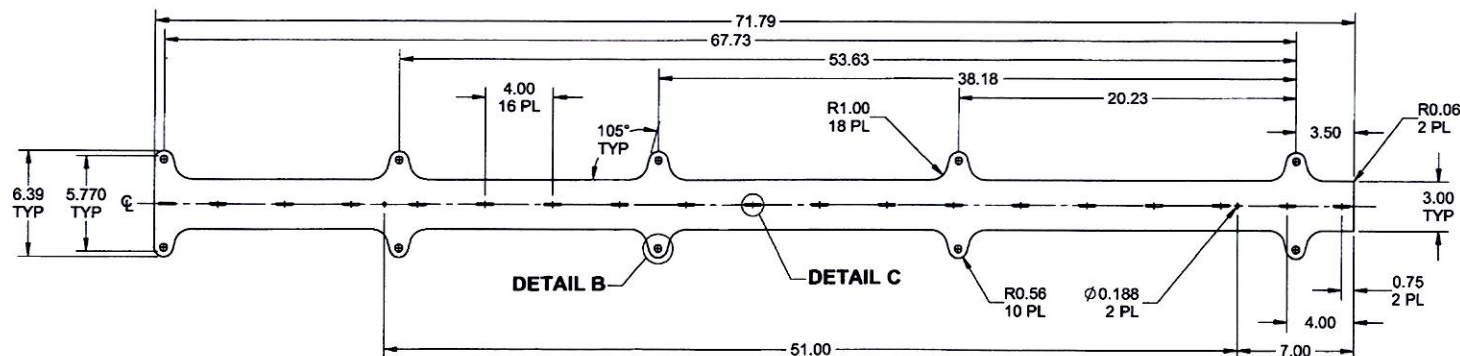
APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D4366-3 PLATE
(MAKE FROM D4366-3F)



D4366-3F PLATE
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.36 lbs

RELEASED
2016-06-16

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1